

Work Order ID 140657

140657

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January 13, 2016 9:24:22 AM

Item ID: D3686-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Monopod Assembly

Start Date: 1/13/2016 Start Qty: 4.00

***4*3**
***4*3** *5H*

Cust Item ID:

Required Date: 1/27/2016 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: *SLA*

Date: *20160501*

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3686	F								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00				<u>3</u>	<u>FF</u>		JAN 26 2016
Packaging									
110	Small Fab	0.00							
110									
Small Fab	Memo	0.02				<u>3</u>	<u>FF</u>		JAN 26 2016
Small Fab	1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684								
	2-Assemble as per Dwg D3684								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

Work Order ID 140657***140657***

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Item ID: D3686-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Monopod Assembly

Start Date: 1/13/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/27/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-88
120						(3)			JAN 26 2016
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location <u>231A</u>	0.00							DAS 6 9-88
130						3		JAN 26 2016	
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140								JAN 27 2016	
QC	Memo	0.01							
Quality Control									

JAN 27 2016

MCJ

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
				OTHER :							

Picklist Print

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Work Order ID: 140657

140657

Parent Item: D3686-041

D3686-041

Parent Item Name: Monopod Assembly

Start Date: 1/13/2016

Required Date: 1/27/2016

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A new issue 08-02-12 DD verified by:JLM
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
 IPP Rev:D Added sealant note as per Rev C 09-01-20 JLM
 Verf:DD
 11.12.05 as per dwg revE DD verf:EC

IPP

IPP REV:E

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3691-041 *D3691-041* Stud Assembly		Manufactured	No				Each	3.0000		4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				3					
					137672			3					
D3688-047 *D3688-047* Stud Assembly		Manufactured	No				Each	7.0000		4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				7					
					109346			7					
D3689-1 *D3689-1* Sleeve		Manufactured	No				Each	10.0000		4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				2					
					83358			2					
				st510				8					
					105605			8					

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FF

JAN 26 2016

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FF

JAN 26 2016

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DAS

6

9-89

JAN 26 2016

3

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Work Order ID: 140657

140657

Parent Item: D3686-041

D3686-041

Parent Item Name: Monopod Assembly

Start Date: 1/13/2016

Required Date: 1/27/2016

Start Qty: 4.00

Required Qty: 4.00

NAS509L12C

Purchased

No

Each

67.0000

4

NAS509L12C

Nut

DAS
6
9-89

Location

Loc Qty

Loc Code

CCK007

66

m128578

66

ST265

1

120498

1

Each

36.0000

4

NAS509-12C

Purchased

No

NAS509-12C

Nut

DAS
6
9-89

Location

Loc Qty

Loc Code

ST261

36

m128199

4

m128429

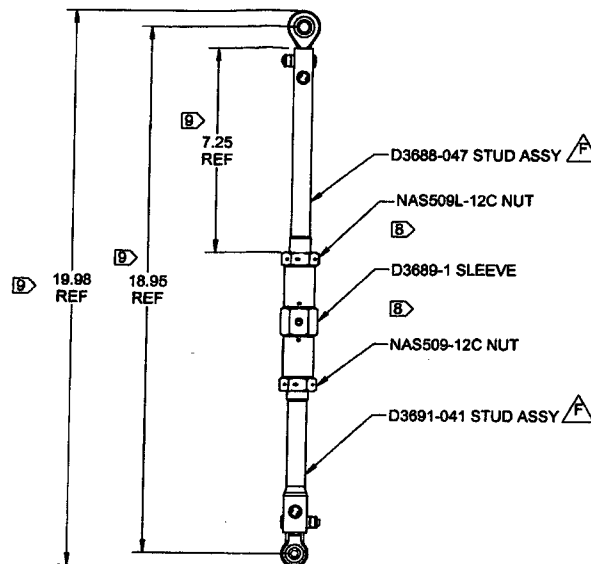
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JAN 26 2016

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3688-041	MONOPOD ASSEMBLY
2	1	D3688-047	STUD ASSY
3	1	D3689-1	SLEEVE
4	1	D3691-041	STUD ASSY
5	1	NAS509L-12C	NUT
6	1	NAS509-12C	NUT



D3686-041 MONOPOD ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3688-041 PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 2.92 lbs
- 8) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD.
- 9) DIMENSIONS SHOWN ARE WHEN D3688-047 & D3691-041 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES.

20160113
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RELEASED
2013-01-22

F	D3688-047 WAS D3688-7 D3691-041 WAS D3691-1 (ZN C3-1); RE-FORMAT NOTES SECTION AS PER QSI 043. REMOVE ASSEMBLY INSTRUCTIONS FROM NOTES (ZN A8-1). CHANGE BOM TABLE TO REFLECT NEW ASSEMBLY STRUCTURE (ZN D6-1). REF. NCR 12-2074.	DB	12.12.05
E	QTY(2) MS21250-03014 STEEL TENSION BOLTS AND QTY(2) MS21042-3 NUT REPLACE QTY(2) AN3C12A BOLTS AND QTY(2) MS21043-3 NUT (ZN B3-1 & C6/D6-1). REASON: PRODUCT IMPROVEMENT (REF. NCR11-784)	MB	11.11.23
D	19.98 WAS 20.10 (ZN C8-1); 18.95 WAS 19.07 (ZN C5-1)	RF	10.03.03
C	ROD END BEARINGS NOW ASSEMBLED USING SEALANT (ZN A8-1, B4-1)	RF	08.12.15
B	REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB	DRAWING NO.	REV. F
CHECKED	JLM	D3686	SHEET 1 OF 1
MFG. APPR.	JLM	TITLE	SCALE
APPROVED	JLM	MONOPOD ASSEMBLY	NTS
DE APPR.	JLM	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.12.05		